

Work Order ID 83876

83876

Page 1

April-26-12 2:31:31 PM

Item ID: D3278-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: 80 Stop ***NS2***
 Item Name: Support 80
 Start Date: 26/04/2012 Start Qty: 120.00 ***120*** Cust Item ID:
 Required Date: 10/05/2012 Req'd Qty: 120.00 ***120*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/26 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								

100
100 BAND SAW 0.00
 Bandsaw Memo 0.00 12-4-30 80
 Jeaspa Bandsaw Cut blank: 2.00" x 1.00" x 2.550" long

110 Parab
110 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS I Memo 0.00 80
 HAAS CNC vertical machine #1 1- Machine as per Folio FA405 and Dwg D32782- Debur and
 Tumble identify as D3278-1 12/05/03 120

120
120 QC Rec'd 0.00
 Quality Control QC2-Inspect parts off machine FAI/FAIB 79x 80
issue PHOTO A.T.C P/O: 16887
machine as per Dwg D3278 REC.C
Rec'd + inspect for transit damage.
attached c/c to W/O. 12-5-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83876

83876

April-26-12 2:31:31 PM

Page 2

Item ID: D3278-1

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 26/04/2012 Start Qty: 120.00

120

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200 F

10-15

9:45

cut
X78

79 2/5 12-5-29

79X 12/05/31

M-21134

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 83876

April-26-12 2:31:31 PM

83876

Page 3

Item ID: D3278-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 26/04/2012 Start Qty: 120.00

120

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

79 6 12531

170

Identify as per dwg & Stock Location QA

0.00

170

Packaging

Memo

0.00

Packaging

79x 125/31

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/6/4

ME 12-06-01

W/O:		WORK ORDER CHANGES					
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Picklist Print

April-26-12 2:36:11 PM

Page 1

Work Order ID: 83876

83876

Parent Item: D3278-1

D3278-1

Parent Item Name: Support

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP: A04.04.19New issueKJ/JLM
IPP B 07.09.06 rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased			No	100	f	77.2100	0.2337	29.52			

M6061T6B1 000X02 000

6061-T6 Bar 1.00 x 2.00

Location	Loc Qty
MAT003	23.646
112567	16.6
118106	7.046
MAT004	53.564
120603	35.164
121040	18.4

Loc Code

** 78x 8p 12-5-28

10 12-4-30
10 12-4-30

D 3278-1P

X 120 80

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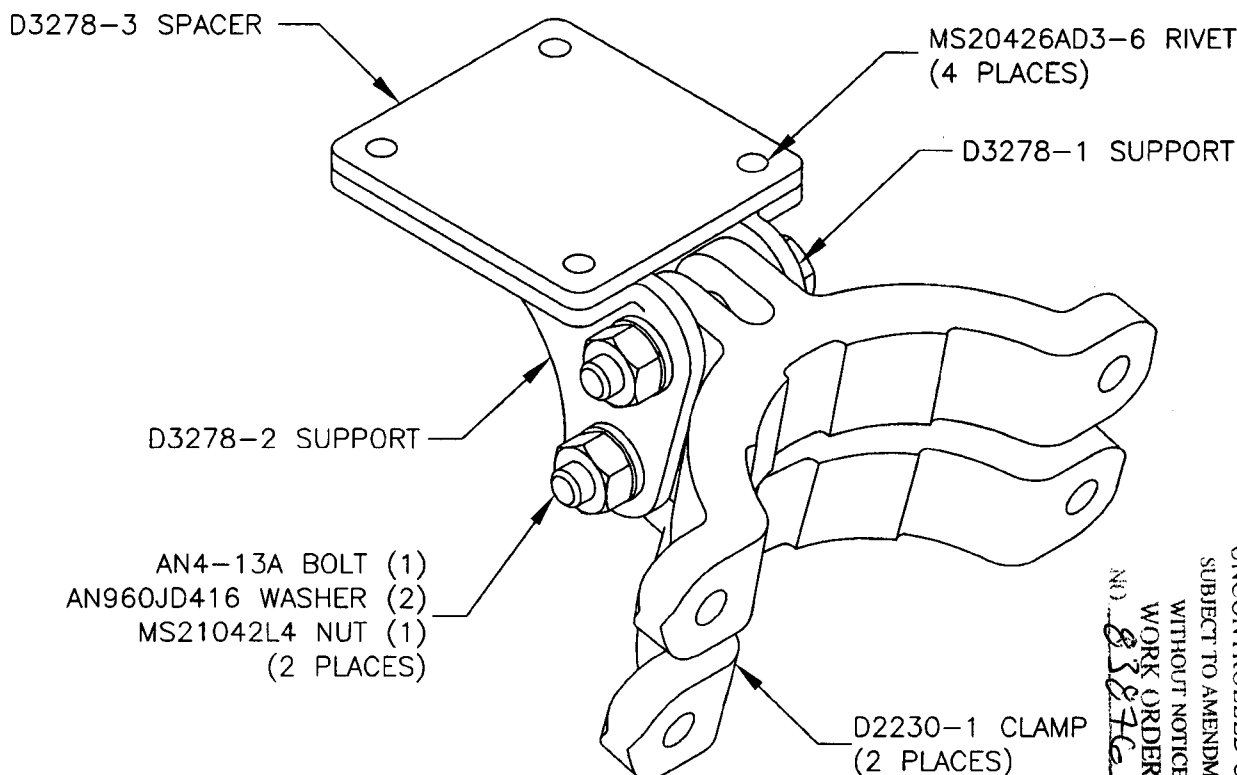
NOTE: Date & initial all entries

DART

DESIGN 97	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

NO. 83876 MCJ 12/04/20
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

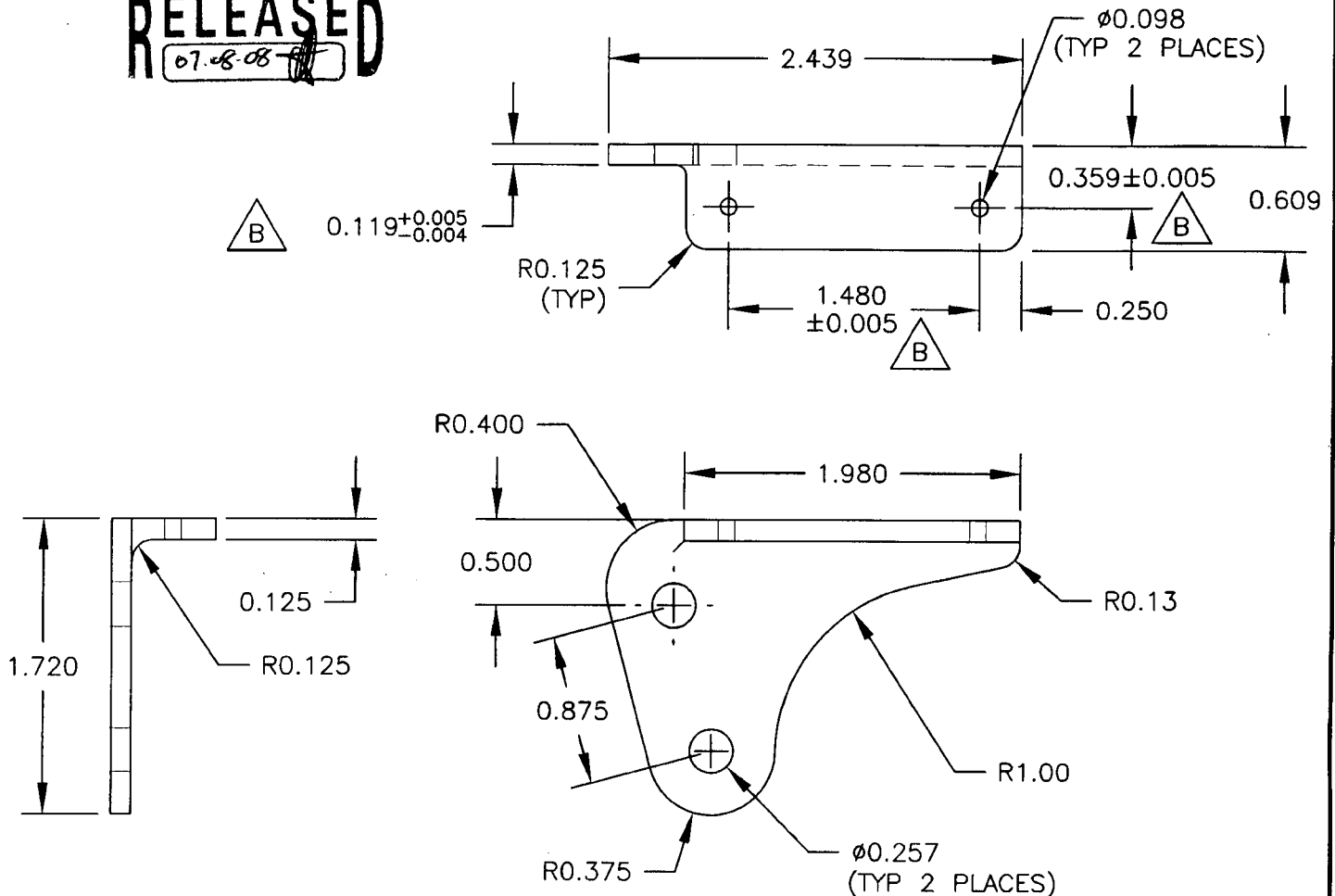
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

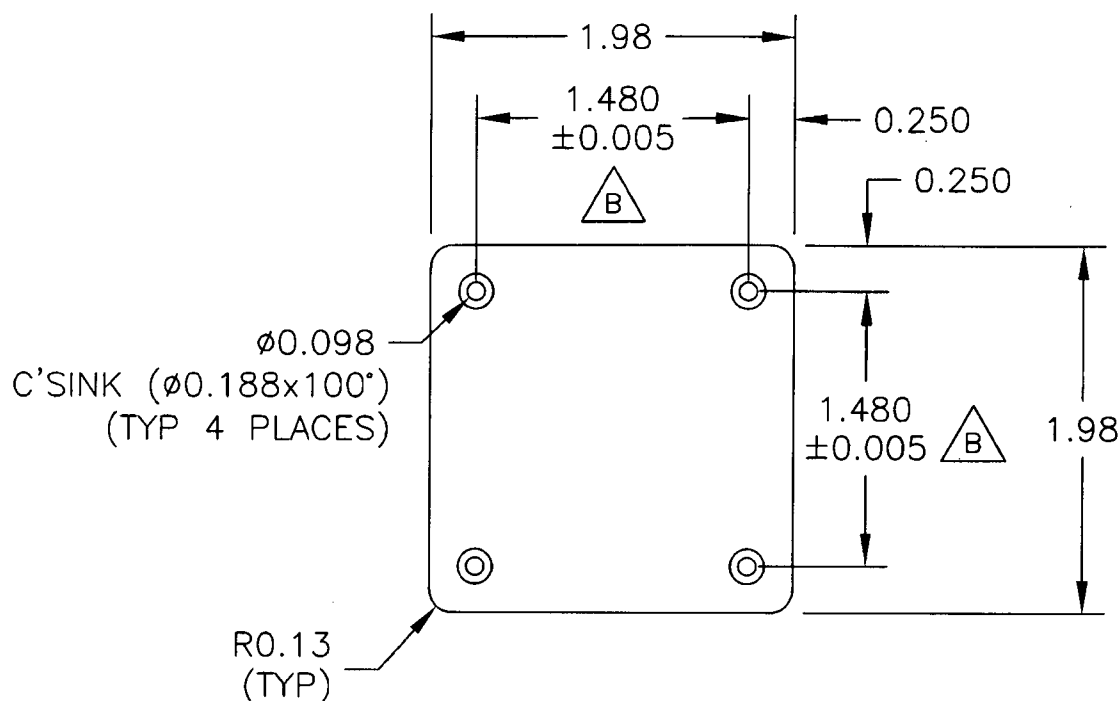
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

63876

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A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
CANADA

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 904284

Date: 23-May-12

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Ship To

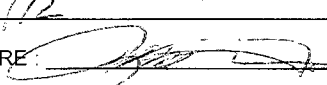
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
119 ea	Part: D3278-1P SUPPORT, SIDE 1 Job: 12892	Rev: C PO: PO16887	Line: 1 & 5
120 ea	Part: D3278-2P SUPPORT, SIDE 2 Job: 12893	Rev: C PO: PO16887	Line: 2 & 6
58 ea	Part: D3404-1P GHW LUG Job: 12894	Rev: C PO: PO16887	Line: 3
58 ea	Part: D3414-3P LUG ASSEMBLY Job: 12895	Rev: C PO: PO16887	Line: 4
DATE: 23/05/12			
CERTIFIED SIGNATURE: 			
RECEIVER SIGNATURE: _____			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT ARE IN CONFORMANCE WITH THE REQUIREMENTS, SPECIFICATIONS, AND DRAWINGS REFERENCED IN THE ABOVE PURCHASE ORDER. I.S.O. 9001 : 2008 REGISTERED / MADE IN CANADA			